

# Work Order ID 57127

March 23, 2010 11:46:20 AM



Page 1

Item ID: D2221

Accept



Setup Start



Revision ID:

Stop



Item Name: 350 Basket Base

Start Date: 23/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 30/03/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*Handwritten signature*

Date: 10-3-23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2221

Rev H

100



Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221  
2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221  
3- tack weld mesh on basket as per dwg D2221  
A/R ER316 S.S. Rod Batch: 111679

*Handwritten signature* 10.04.09

110



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

*Handwritten signature* 10.04.09



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Page 2

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Revision ID:

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Stop



Start Date: 23/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 30/03/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

8/10/04/12

Q2

Quality Control

130

White Gloss(Ref 4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

=> 10/10/04/12

1 /

Powder Coating

Plug holes prior to

1ST COAT:

START TIME: 11:00pm

OVEN TEMPERATURE: 400°C

FINISH TIME: 11:30pm

\*\*\*\*\* 2nd coat if necessary\*\*\*\*\*

2ND COAT:

START TIME: 12:00pm

OVEN TEMPERATURE: 400°C

FINISH TIME: 12:30pm

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: G-A

0.00



Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*EB 10/04/12 @*

*EB 10/04/12 @*

*10/04/12*

*mf  
104-12*

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



# Picklist Print

March 23, 2010 11:46:24 AM

Page 1

Work Order ID: 57127

Parent Item: D2221

Parent Item Name: 350 Basket Base

Comments: IPP Rev:J 05.09.02 Added D3442-1 ☐ KJ/JLM  
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC  
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC  
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Date: 23/03/2010

Required Date: 30/03/2010

Start Qty: 1.00

Required Qty: 1.00

D2221-1  
 Rib  
 Manufactured No 100 Each 9.0000 1.0000

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	WA	9	
	48101	1	
	55977	8	

SAD 10-04-06

D2221-5  
 Rib  
 Manufactured No 100 Each 4.0000 2.0000

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	WA	4	
	55652	4	

SAD 10-04-06

D2221-7  
 Rib  
 Manufactured No 100 Each 2.0000 1.0000

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	WA	2	
	55651	2	

SAD 10-04-06

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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March 23, 2010 11:46:24 AM

Page 2

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 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC  
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Date: 23/03/2010

Required Date: 30/03/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D2232-3 Manufactured No 100 Each 15.0000 2.0000



Basket Hinge



SAD 10-04-06

Warehouse	Loc Qty	Loc Code
Location		

Main Warehouse

WA	15	
50024	2	
54863	13	

✓ D2235-1 Manufactured No 100 Each 17.0000 2.0000



Basket Rib



SAD 60-04-06

Warehouse	Loc Qty	Loc Code
Location		

Main Warehouse

WA	17	
50565	3	
55979	4	
56472	10	

March 23, 2010 11:46:24 AM

Shop Packet Print

Page 2





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March 23, 2010 11:46:24 AM

Page 3

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 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC  
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Date: 23/03/2010

Required Date: 30/03/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D2581



Mounting Bracket

Manufactured No 100 Each 35.0000 2.0000



SAD 10-04-06

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
WA	35	
46086	2	
48428	1	
50872	1	
51120	2	
51745	2	
55918	27	

✓ D3442-1



Shim

Manufactured No 100 Each 29.0000 2.0000



SAD 10-04-06

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
WA	29	
46767	1	
54071	9	
56579	19	

March 23, 2010 11:46:24 AM

Shop Packet Print

Page 3





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March 23, 2010 11:46:24 AM

Page 4

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 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC  
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Date: 23/03/2010

Required Date: 30/03/2010

Start Qty: 1.00

Required Qty: 1.00

D3825-041



Rib Assembly (Basket End)

Manufactured No 100 Each 8.0000 2.0000



SAD 10-04-06

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
WA	8	
54865	2	
56205	6	

D3826-041



Rib / Gusset Assembly

Manufactured No 100 Each 6.0000 2.0000



SAD 10-04-06

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
WA	6	
56207	6	

D3827-041



Rib Assembly (Inboard)

Manufactured No 100 Each 9.0000 1.0000



SAD 10-04-06

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
WA	9	
54866	3	
55982	6	

March 23, 2010 11:46:24 AM

Shop Packet Print

Page 4





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March 23, 2010 11:46:24 AM

Page 5

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 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC  
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Date: 23/03/2010

Required Date: 30/03/2010

Start Qty: 1.00

Required Qty: 1.00

D3832-1



Mesh (Base)

Manufactured No 100 Each 3.0000 1.0000



*lpl 10.04.08*

Warehouse  
Location  
Loc Qty  
Loc Code

Main Warehouse

WA

3

56179

3

100

Each

13.0000

2.0000



*1*

*lpl 10.04.09*

D3833-1



Mesh (Base End Face)

Manufactured No

Warehouse  
Location  
Loc Qty  
Loc Code

Main Warehouse

WA

13

50025

2

55843

3

56396

8

*2*

March 23, 2010 11:46:24 AM

Shop Packet Print

Page 5







**D2221 BASKET BASE ASSEMBLY (AS350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 57127  
10-3-23

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

RE 08/11/18

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 42.00 lbs APPROX
  - 8) MASK ALL HOLES PRIOR TO POWDER COATING

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3625-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1 REASON: SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL. TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	06.06.15
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BW		
CHECKED	JSS	DRAWING NO.	REV. H
MFG APPR.	JSS	D2221	SHEET 1 OF 5
APPROVED	JSS	TITLE	SCALE
DE APPR.	JSS	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

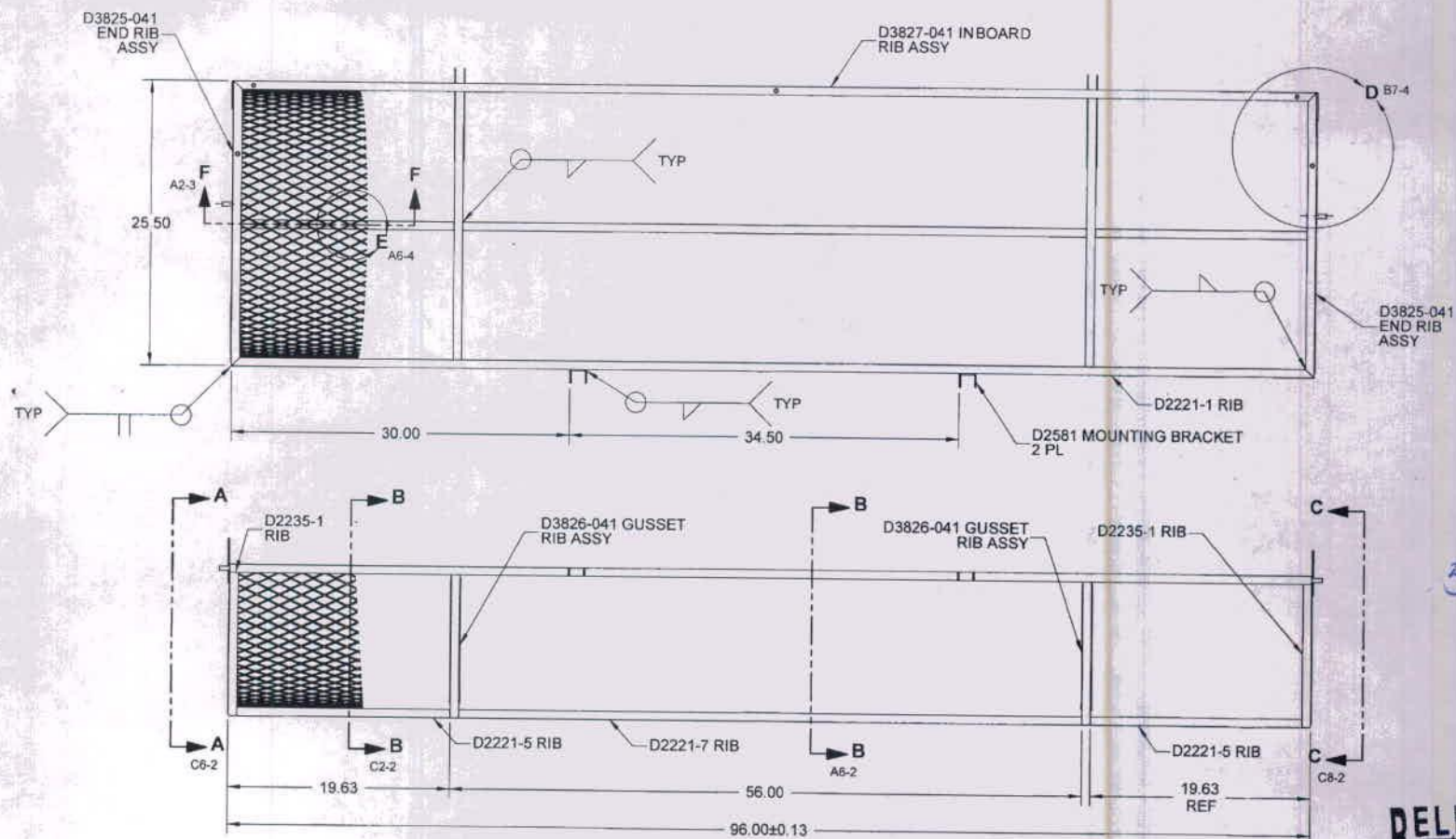
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





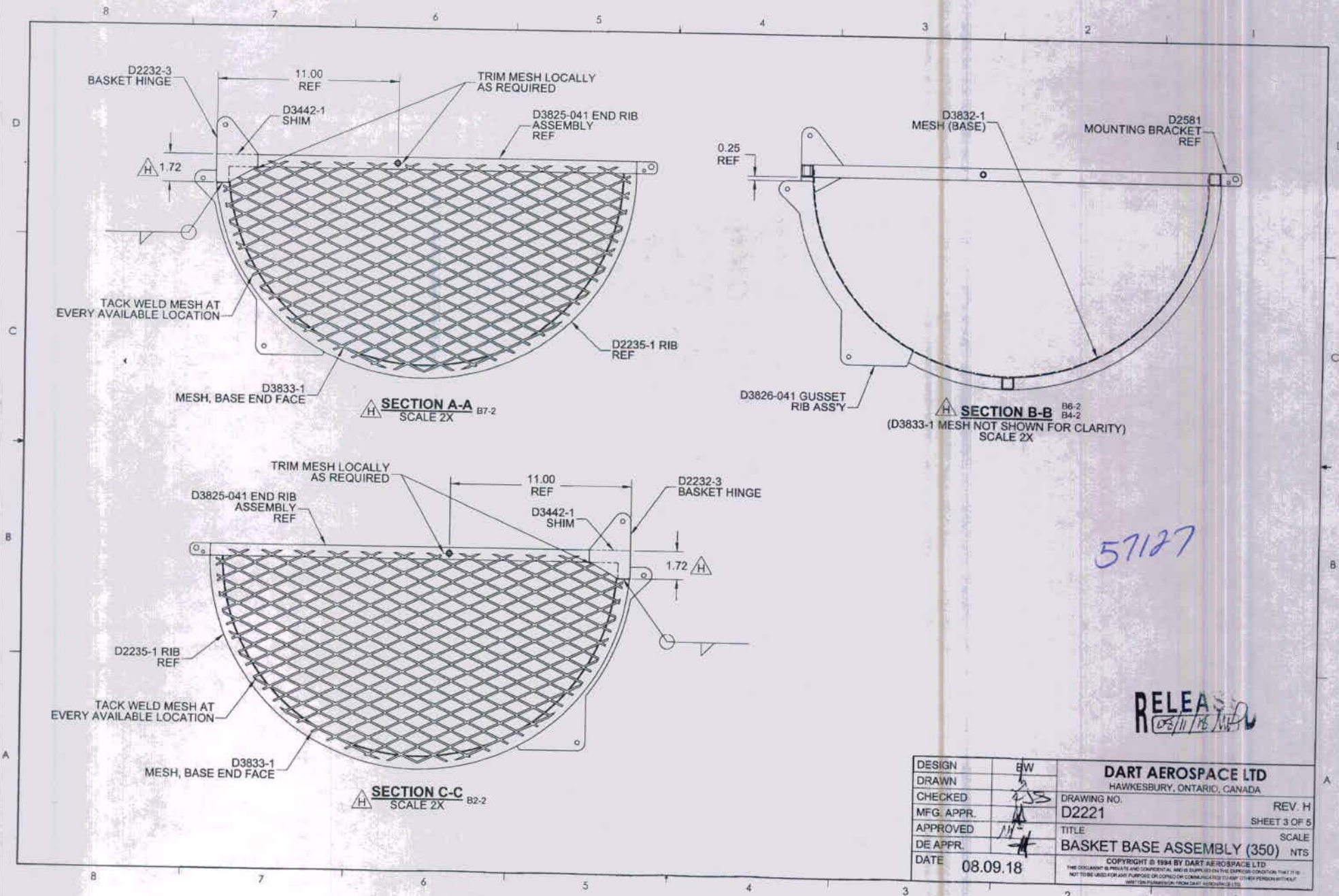
**D2221 BASKET BASE ASSEMBLY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED  
06/11/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	COPYRIGHT © 1984 BY DART AEROSPACE LTD	
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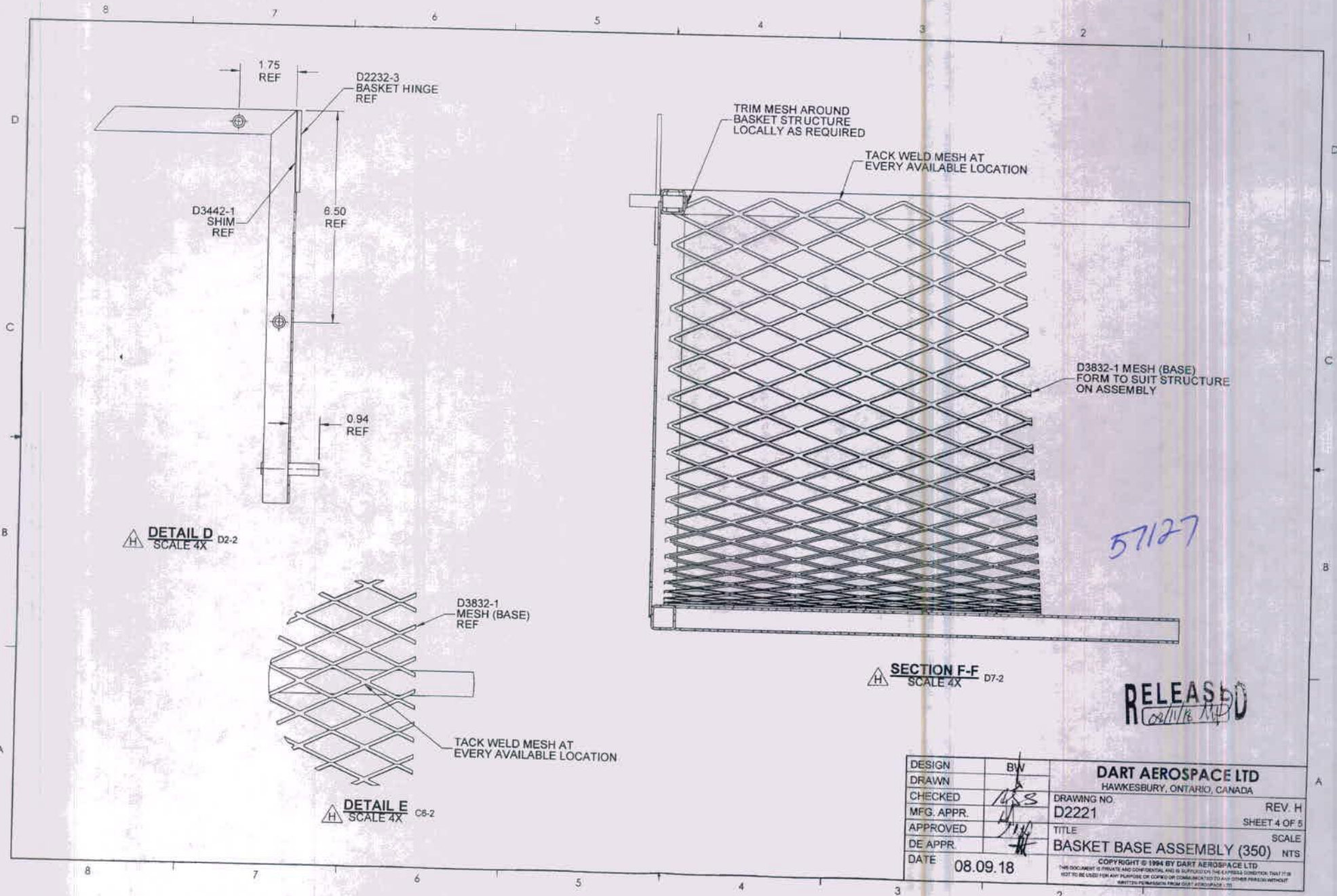
57127

RELEASED  
03/11/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	3	HAWKESBURY, ONTARIO, CANADA	
CHECKED	233	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 3 OF 5
APPROVED	11	TITLE	SCALE
DE APPR.	11	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD.	
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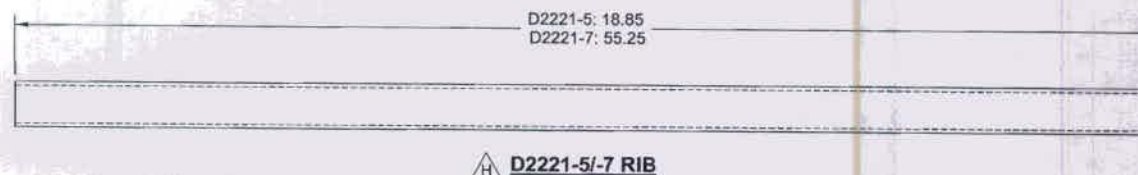
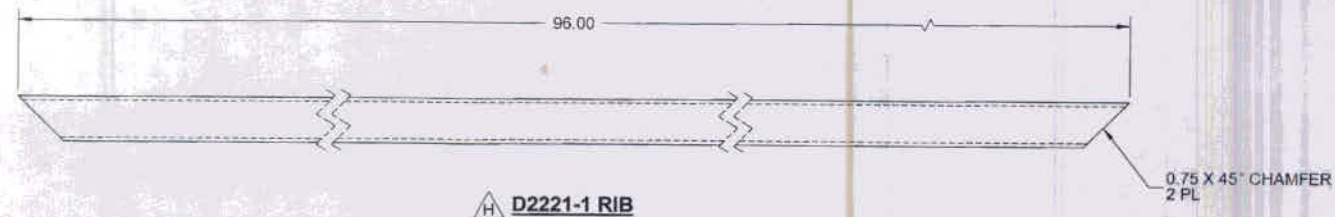
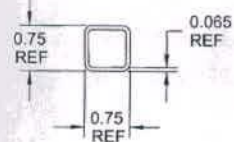
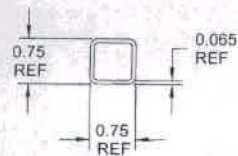












57127

RELEASED  
06/11/18

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 8) WEIGHT: D2221-1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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